

Date: Thursday, 2/9/2006 1:17:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 25794		
Estimate Number	: 11527		
P.O. Number	: N/A	Part Number	: D3021041
This Issue	: 2/9/2006 S.O. No. : N/A	Drawing Number	: D3021 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 25793	Material	: N/A
Written By	: <i>See comment below</i>	Due Date	: 3/15/2006
Checked & Approved By	: <i>06.02.09</i>	Qty:	1 Um: Each
Comment	: Est. 01.10.23 New Issue SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall batch: <i>M1049B</i> <i>11/06/07/25 ①</i>		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut tube as per Dwg D3021 2-Drill tube as per Dwg D3021 using D3021-041T1 3--Deburr <i>11/06/07/25 ①</i>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <i>PD 06-07-28</i>		
4.0	M4130NS049	4130 Sheet .049 wall
Comment: Qty.: 1.0500 sf(s)/Unit , Total : 1.0500 sf(s) 4130 Sheet .049 wall Cut:- AISI 4130N sheet, 18 gauge (0.050 thick) batch: <i>M16443</i> <i>11/06/07/28 ①</i> Identify For D3017-11 Cap		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/08/15.
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:17:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 25794

Part Number: D3021041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut end caps as per Dwg D3017

2-Weld as per Dwg D3021

A/R Steel Rod Batch: M9430

PD 06/07/28 ①

6.0

QC5/9

WELD INSPECTION



Comment: VISUAL WELDING INSPECTION

Inspect Level 9

Inspect for foreign objects per QSI 024

PD 06-07-28

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SC 06/27/31 ①
DU

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/08

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location GA

SB 06/08/08

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/08/15 ①

Job Completion



W 06.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

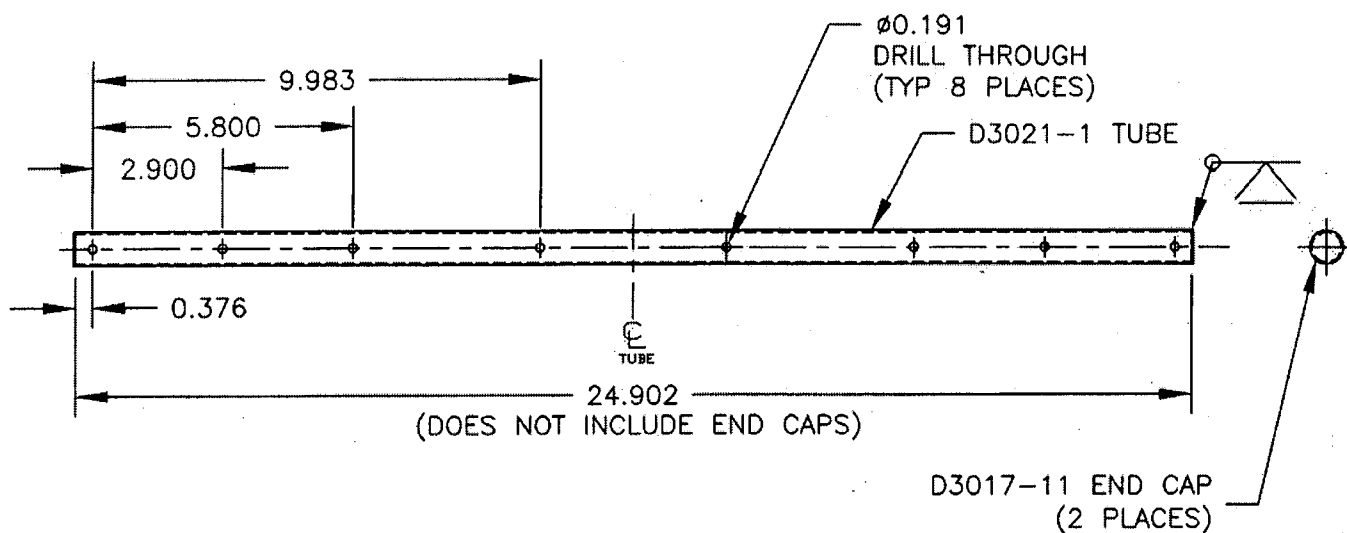
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA \times 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005.4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25794

RELEASED
01.05.2018

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.